

Work Order ID 90509

September-19-12 9:02:16 AM

90509

Page 1

Item ID: D2739

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: 350 I Beam

Start Date: 19/09/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/10/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-09-19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2739	Rev E
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100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-5 to length as per Dwg D2739.
2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739
3-Use uni-bit to open holes to finish size as per Dwg D2739.
4-Bevel Fwd end of extrusion and Deburr holes and ends.
5-Deburr

4 12/09/19

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

4 12-9-24

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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QA Closed: _____ Date: _____

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Page 2

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Required Date: 03/10/2012 Req'd Qty: 4.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control



12-9-24

(4)

140

Identify as per dwg & Stock Location: 46

0.00

140

Packaging

Memo

0.00

Packaging

DP

12-9-24

(4)

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/9/24

MF
12-09-24

NCR: Yes / No

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Picklist Print

September-19-12 9:02:20 AM

Page 1

Work Order ID: 90509

90509

Parent Item: D2739

D2739

Parent Item Name: 350 I Beam

Start Date: 19/09/2012

Required Date: 03/10/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: C02.11.28ReformatKJ
 IPP Rev: D 06-03-21 As Per Rev C JLM
 IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F
 10.11.02 as per revE DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2600-5-108

Manufactured No

100

Each

71.0000

1

4

D2600-5-108

**

Extrusion 'I Beam' thin

(4) 12/09/19

Location

Loc Qty

Loc Code

LG

71

47814

20

73909

51

NCR: Yes / No

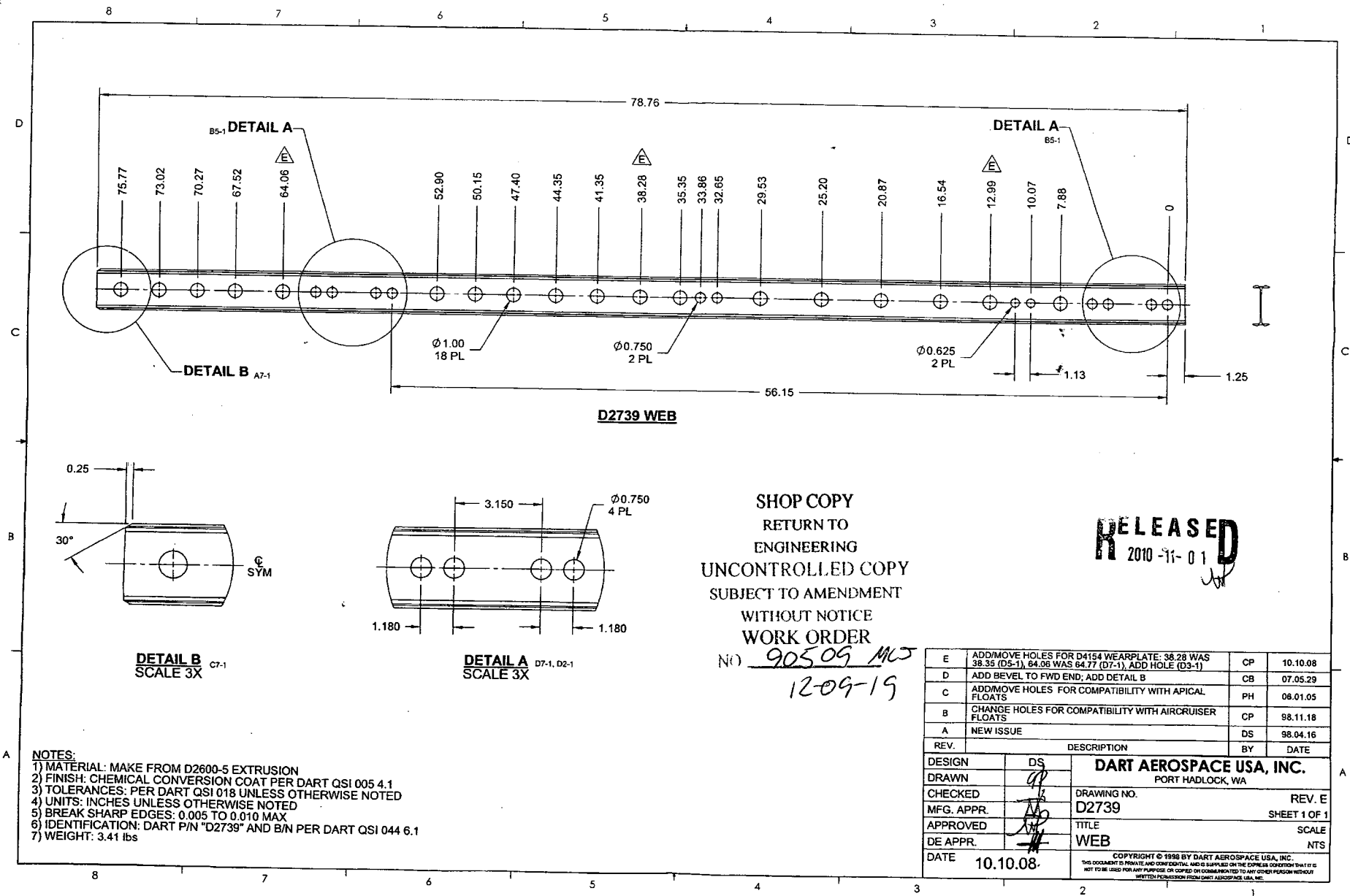
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 90509 MJS
12-09-19

RELEASED
2010-11-01

REV.	DESCRIPTION	BY	DATE
E	ADD/MOVE HOLES FOR D4154 WEARPLATE: 38.28 WAS 38.35 (D5-1), 64.06 WAS 64.77 (D7-1), ADD HOLE (D3-1)	CP	10.10.08
D	ADD BEVEL TO FWD END; ADD DETAIL B	CB	07.05.29
C	ADD/MOVE HOLES FOR COMPATIBILITY WITH APICAL FLOATS	PH	08.01.05
B	CHANGE HOLES FOR COMPATIBILITY WITH AIRCRUISER FLOATS	CP	98.11.18
A	NEW ISSUE	DS	98.04.16
DESIGN	DS	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2739 TITLE WEB SCALE NTS <small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	
DRAWN	CP		
CHECKED	CP		
MFG. APPR.	CP		
DE APPR.	CP		
DATE	10.10.08	REV. E	SHEET 1 OF 1

NCR: Yes / No

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